

Friday, May 06, 2016 10:56:34 AM

Page 1

Quality Control

16/08/08

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____																		

Work Order ID 145834

Friday, May 06, 2016 10:56:34 AM

145834

Page 2

Item ID: D2958

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Window

Start Date: 4/27/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/5/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp
DAS
07
9-89

130

130

Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

Memo

0.00

Thermoform as per Dwg D2958 and Work Instruction WI005

Check for Visual Clarity

Dwg. Rev. EWI Rev. Ex2

160

160

Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

0.00

Water sand and buff to remove scratches as required Wrap in protective film

x2**DAS**
07
9-89

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 145834

Friday, May 06, 2016 10:56:35 AM

145834

Page 3

Item ID: D2958

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Window

Start Date: 4/27/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/5/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC5- Inspect part completeness to step on W/O	0.00							
170									DAS
QC	Memo	0.00							9
Quality Control									9-89
180	Identify as per dwg & Stock Location: <u>5458</u>	0.00							
180									DAS
Packaging	Memo	0.00							6
Packaging									9-89
190	QC21- Final Inspection - Work Order Release	0.00							
190									DAS
QC	Memo	0.00							21
Quality Control									9-89

② 160816

2 PK

AUG 10 2016

DAS
21
9-89

AUG 17 2016

DAS
21
9-89

AUG 17 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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OTHER : _____									

Picklist Print

Friday, May 06, 2016 10:56:34 AM

Page 1

Work Order ID: 145834

145834

Parent Item: D2958

D2958

Parent Item Name: Window

Start Date: 4/27/2016

Required Date: 5/5/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP E: 01.09.25 Done by outside contract SM
IPP F: 07.06.26 Thermoform in house DL
IPP G: 07.09.28 Rev E dwg EC verified by: DD
IPP H: 08.11.24 Step 8 revised per w/o 41134 KJ Verified by: EC
IPP Rev I 14/01/20 Change "Folio" to Work Instruction DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased			No	100	sf	159.7670	2.58	5.431579			

MACRLICS 125

1/8" Polycast II Sheet

PR 2016/08/08

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT019	159.767	
m130047	22.667	
m131524	55.1	
m132799	8.7	
m133510	9.3	
m134641	64	<i>S.P</i>

DQA: _____ Date: _____

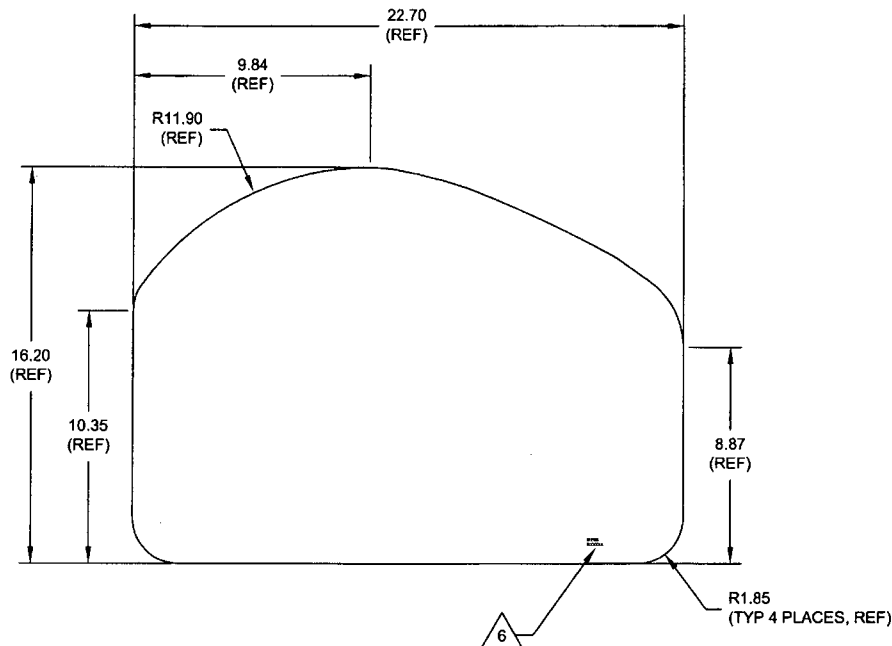


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OTHER : _____					



D2958 FLAT PATTERN

D2958 WINDOW:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D2958" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.58 +/- 0.35 LBS
- 8) MOLD PER DART TOOL DT8567

COPY
TO
RING
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NDMENT
ICE
ER
145.834_MLS
1605-09

RELEASED
07.09.22

E	UPDATE DIMS PER PAR 188	DC	07.07.06
D	UPDATE MATERIAL PER NCR 029	SSH	06.04.13
C	REMOVE HOLES, UNIFORMLY SMALLER	CP	01.05.30
B	Ø0.156 HOLES WERE Ø0.141 (NCR 407)	CP	00.02.23
A	NEW ISSUE	CP	00.01.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2958	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		WINDOW	1:5
DATE	07.07.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	